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D3043-042
Job Sheet 199101



Part No: D3043-042

Job Qty: 3 pcs

Part Name: Step Weldment RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Due Date: 12/2/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev :A New Issue JLM 05-11-01

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	3 pcs	12/2/19		0.00	0.75	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 6	3 pcs	12/2/19		0.00	0.00	Large Fab - 11 (Various)		
							QC 6 - 9		
							QC 6 - 68		
							QC 6 - 61		
							QC 6 - 40		
120	Large Fab - Steps - 2 - B4B	3 pcs	12/2/19		0.00	2.00	QC 6 - 81		
							Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
130	QC 9	3 pcs	12/2/19		0.00	0.00	Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		

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140 QC 5	3 pcs	12/2/19	0.00 0.00	QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS
				QC 5 - 3	24
				QC 5 - 43	9-89
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Handfinish - 1-1 Chemical-B4B	3 pcs	12/2/19	0.00 0.50	Handfinish - 1 - 1 - B4B	BEB 19-10-25
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Large Fab - Steps - 3 - B4B	3 pcs	12/2/19	0.00 1.50	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B	
				(Various)	
170 QC 10	3 pcs	12/2/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	DAS
				QC 10 - 24	24

180 QC 5	3 pcs	12/2/19	0.00 0.00	QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 6-1- Touch Up- B4B	3 pcs	12/2/19	0.00 0.50	Handfinish - 6 - 1 - B4B	
				Handfinish - 6 - 2 - B4B	BEB19-10-29
				Handfinish - 6 - 3 - B4B	
				Handfinish - 6 - 4 - B4B	
				Handfinish - 6 - 5 - B4B	
				Handfinish - 6 - 6 - B4B	
				Handfinish - 6 - 7 - B4B	
				Handfinish - 6 - 8 - B4B	
				Handfinish - 6 - 9 - B4B	
				Handfinish - 6 - 10 - B4B	
				Handfinish - 6 - 11 - B4B	
				Handfinish - 6 - 12 - B4B	
				Handfinish - 6 - 13 - B4B	
				Handfinish - 6 - 14 - B4B	
				Handfinish - 6 - 15 - B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
210 Powdercoat - 1 White Gl(A)- B4B	3 pcs	12/2/19	0.00 0.75	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB19-10-31
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
220 Handfinish - 3-1- WingWalk- B4B	3 pcs	12/2/19	0.00 1.50	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
230 QC 3	3 pcs	12/2/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	

				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
240	Packaging 3-1 - Stock - B4B	3 pcs	12/2/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
250	QC 21 - SA	3 pcs	12/2/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - Fabricate per Drwg)1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup
 Descriptions: DT8185-G 2-Deburr and bevel ends for welding

- 110 - (QC6- All purchased or subcontracted products)
 120 - 1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808 AR AL ROD
 Batch: 0138989 2-Grind Fwd End Cap weld flush
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (Fabricate per Dwg) 1-1-Weld 1 End Cap as per QSI 004 & Dwg AR AL ROD Batch: _____ 2-Inspect for foreign object as per QSI 024 3-Grind Fwd End Cap weld flush
 170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Touch up alodine)
 210 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-START Time: 12:30 OVEN TEMPERATURE: 320°
 FINISH TIME: 1:00 5211886
 220 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 230 - QC3- Inspect Part Finish)
 240 - Identify as per dwg & Stock Location: _____
 250 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	3 pcs (1 ea)	100-Large Fab - Steps - 1	<u>52217766</u>
D2734	Step End Plate	3 pcs (1 ea)	120-Large Fab - Steps - 2 - B4B	<u>5198347</u>
D3040-1	Mounting Lug	6 pcs (2 ea)	120-Large Fab - Steps - 2 - B4B	<u>5213057</u>
D3040-3	Mounting Lug	6 pcs (2 ea)	120-Large Fab - Steps - 2 - B4B	<u>5213129</u>
D2734	Step End Plate	3 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	<u>5225431</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	3	15	0
120-Large Fab - Steps - 2 - B4B	D2734	3	50	0
	D3040-1	6	0	0
	D3040-3	6	0	0
160-Large Fab - Steps - 3 - B4B	D2734	3	50	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>199101</u> Part No. <u>D3043-042</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☒ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date : <u>DEC 20 2019</u>	Sequence #: <u>230 QC 3</u>	QTY Affected : <u>3/3</u>		MRB (QSI042) DAS 9 9-89 <u>19.12.20</u>	
Description Work Order Deviation <u>PARTS COVERED WITH FISH EYES</u>		Disposition <u>Scrap destroy</u> <u>no worth the rework.</u>		Completed By 	
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☒ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☒ Marks/Chatter Mislabeled ☐		FAULT CATEGORY Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:					



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Container No: S222064



Part: D3043-042

Job No: 199101

Serial No/Batch: S222064

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/11/19

DEC 30 2019